

Need 08/12

Date: Tuesday, 12/5/2006 8:01:57 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET  
 Job Number : 29749  
 Estimate Number : 10364  
 P.O. Number :  
 This Issue : 12/5/2006 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 29696  
 Part Number : D3046041  
 Drawing Number : D3046 REV. B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 12/23/2006 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : KA 061205  
 Comment : Est: A 01.08.27 New issue SM/EC  
 est: B 06.11.30 Per revB, EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30461 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	29792

06/12/08 (20)

2.0 D30465 HOOK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

LUG

Pick:

Qty	Part Number	Description	Batch
1	D3046-5	Lug	29793

06/12/08 (20)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3046

Rod 17-4 M18774

06/12/08 (20)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.12.08 (20)

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06.12.08 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:01:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 29749

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 26606

C206112108

Heat treat Ass'y as per Dwg D3046

(Heat treat ass'y to H900 hardened condition min 190 KSI)

Possible Supplier: Vac-aero

Certificate of conformity required

(20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

U 06.12.21

(20)

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure certificate of conformity comply to Dwg D3046

U 06.12.21 20

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

PL/a.m

06/12/21 (20X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PL 6/12/22

(20)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5120

PL 6/12/22 (20)

PL 6/12/22 (20)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PL 6/12/22 (20)

Job Completion



C206112122

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

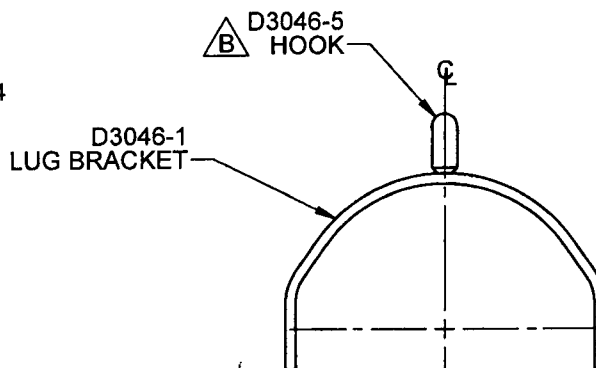
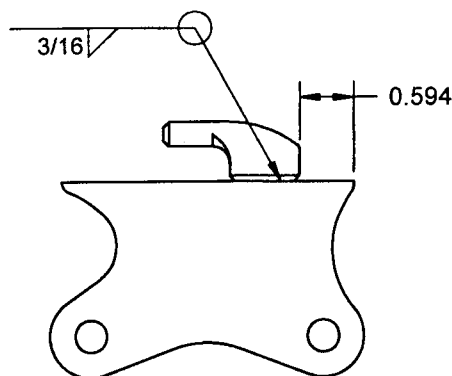
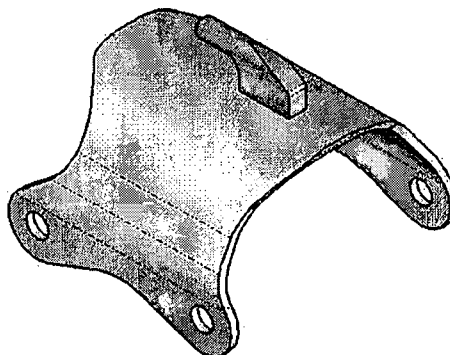
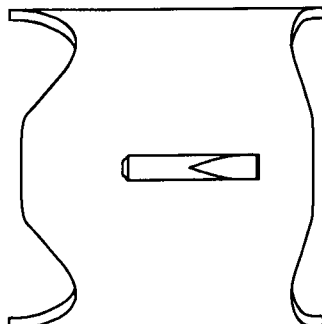
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY C.B.	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3046</b>	REV. B SHEET 1 OF 3
DATE <b>06.10.26</b>		TITLE <b>LUG BRACKET ASSEMBLY</b> SCALE 1:2	
REV	DATE	DESCRIPTION	
A	01.08.23	NEW ISSUE	
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL	

**RELEASED**  
06.11.13 #



**D3046-041 LUG BRACKET ASSEMBLY**

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK



**NOTES:**

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI) POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER NO. 29749

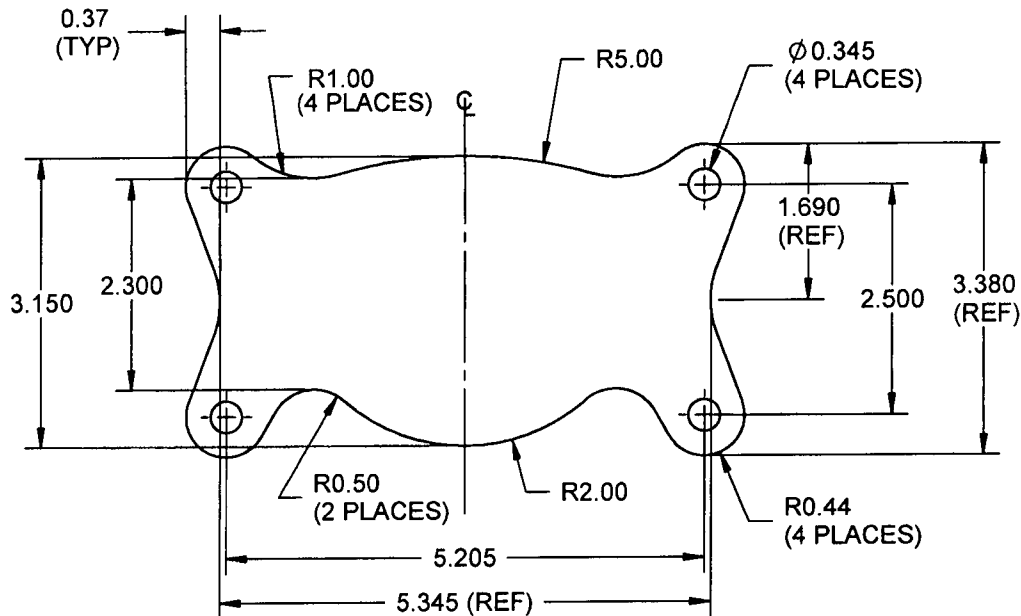
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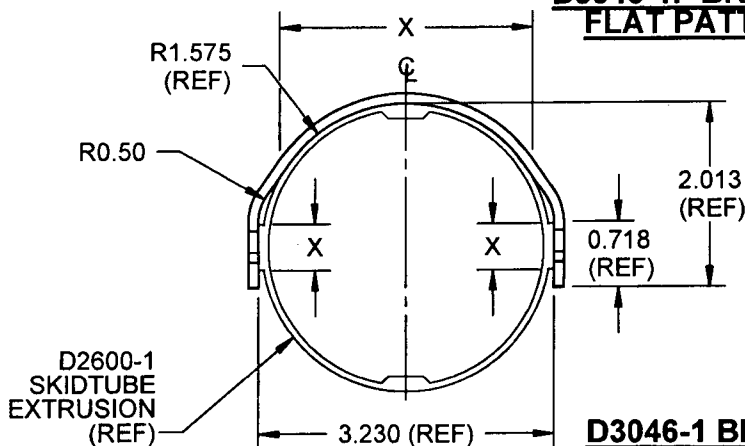
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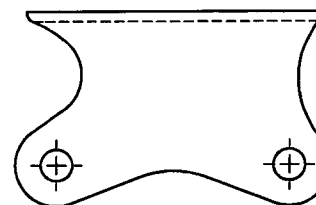
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CHECKED #	APPROVED #	DRAWING NO. <b>D3046</b>	REV. B SHEET 2 OF 3
DATE <b>06.10.26</b>	TITLE <b>LUG BRACKET ASSEMBLY</b>		SCALE 1:2



**D3046-1F BRACKET  
FLAT PATTERN**



**D3046-1 BRACKET  
BEND DETAIL**



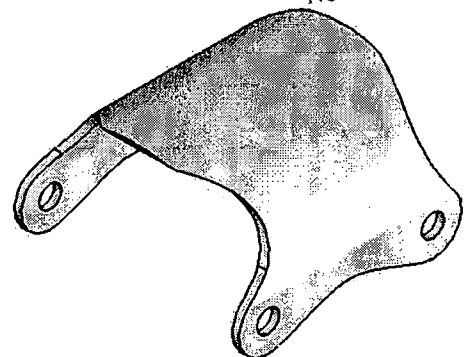
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06/16/13

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NO 29749

**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.



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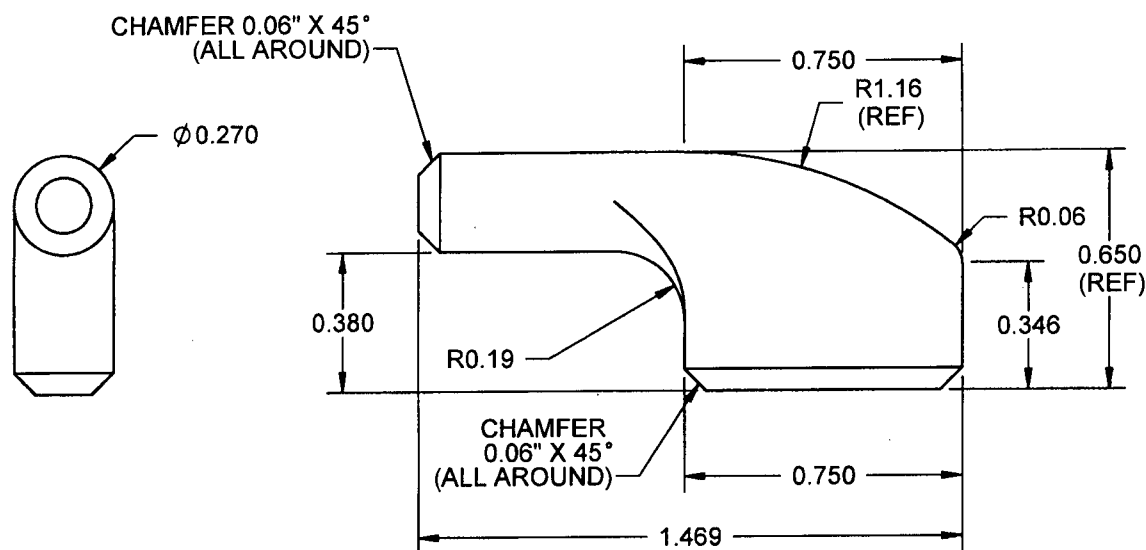
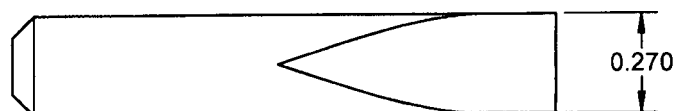
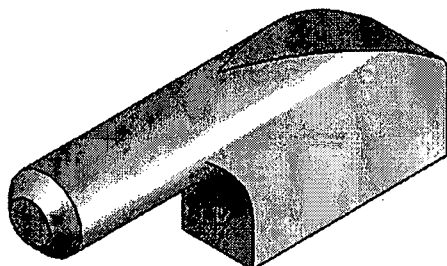
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CHECKED JH	APPROVED JH	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 2:1

**RELEASED**

06.11.13

**D3046-5 HOOK** **NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643 (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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# VAC AERO

INTERNATIONAL INC.

## PACKING SLIP

OAK 82323-1



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No. : R105468102

12/19/2006

MM / DD / YYYY

PAGE : 1

BILL TO: 1DAR01  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
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HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
12/19/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
59048		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D3046 -041	Process Specifications: HEAT TREATED TO H900 COND. (190 KSI) 100% HARDNESS CHECKED AS PER ASTM E-18 MATERIAL: 17-4 PH  B29749	EA	20	20	0
02	MC	MINIMUM CHARGE		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.

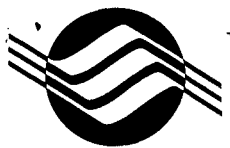


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## RELEASE NOTE

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☐ 2009 WYECROFT ROAD, UNIT B  
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HAWKESBURY, ON

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HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
12/19/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
59048 <i>wybill u</i>		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D3046	-041	EA	20	20	
<p>Process Specifications:</p> <p>HEAT TREATED TO H900 COND. (190 KSI)</p> <p>100% HARDNESS CHECKED AS PER ASTM E-18</p> <p>MATERIAL: 17-4 PH</p> <p>B29749</p> <p><i>u 06-12-21</i></p>					
<div><div>100% HARDNESS TESTED</div><div><i>Qty: 20 Pcs.</i></div><div><i>41/42 HRC</i></div><div><i>20 Dec 06</i></div><div><i>TH. 29 Q.C.</i></div></div>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector

V.A.I.O.  
TH.  
29  
Q.C.



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